



Dart Aerospace Ltd.
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D3537-1**Job Sheet 191068****Part No:** D3537-1**Job Qty:** 40 pcs**Part Name:** Wearpad**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/21/19**Job Tracking No:****Due Date:** 3/18/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG D3537 REV.F IPP Rev:A New Issue 07-02-14 JLM IPP REV:B 15.10.16 added automated welding DD
verf:JLM IPP REV:C 18.11.09 AS PER DWG REV.F DD VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
105	Waterjet - Flow - 1	40 pcs		3/18/19	0.00	1.72	Waterjet - Flow			2/19/04/23
125	QC 8	40 pcs		3/18/19	0.00	0.00	QC 8 - 12			
							QC 8 - 14			
							QC 8 - 17			
							QC 8 - 20			
							QC 8 - 25			
							QC 8 - 3			
							QC 8 - 32			
							QC 8 - 33			
							QC 8 - 35			
							QC 8 - 39			
							QC 8 - 4			
							QC 8 - 44			
							QC 8 - 45			
							QC 8 - 49			
							QC 8 - 58			
							QC 8 - 8			
							QC 8 - 9			
							QC 8 - 68			
							QC 8 - 67			
							QC 8 - 1 (A)			
QC 8 - 47										
all Fab - Brake - 1 - B4B										
all Fab - Brake - 2 - B4B										
all Fab - Brake - 3 - B4B										
QC 5 - 10										
QC 5 - 12										

DART
AEROSPACE

Container No: S174742



Part: D3537 - 1
Job No: 191068
Serial No/Batch: S174742
Revision: F
Inspector:
Exp Date:
Instructions: Various STC's

Date: 04/25/19

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APR 24 2019

DAS 40 9-89

DAS 30 9-89

APR 2 2019

**Container No:** S174742**Part:** D3537 - 1**Job No:** 191068**Serial No/Batch:** S174742**Revision:** F**Inspector:****Exp Date:****Instructions:** Various STC's

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					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EL
					QC 5 - 30	
160	Automated Welding - B4B	40 pcs	3/18/19	0.00 2.97	Automated Welding - 1 - B4B	ML
170	QC 10	40 pcs	3/18/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	EL
					QC 10 - 58	
					QC 10 - 9	
180	QC 5	40 pcs	3/18/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EL
					QC 5 - 30	
210	Packaging 3-1 - Stock - B4B	40 pcs	3/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	EL
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
220	QC 21 - SA	40 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
21
9-36

APR 25 2019

Part Op **105** - 1-Cut D3537-1 as per Dwg D3537 Dwg Rev: F Prog Rev: F 2-Debur if necessary
 Descriptions: **125** - (QC8- Inspect parts - second check)
140 - (Form as per dwg)
150 - (QC5- Inspect part completeness to step on W/O)
160 - (Automated welding) ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR
 AUTOMATED WELDING USE 8259 HARDCOAT BATCH: _____
170 - (QC10- Inspect visual per QSI004- ground welds)
180 - (QC5- Inspect part completeness to step on W/O)
210 - (Identify as per dwg & Stock Location: _____)
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	4.2400 sf (.106 ea)	105-Waterjet - Flow - 1	5152146

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
105-Waterjet - Flow - 1	M304S16GA	4	159	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearpad	4.250inches ± 0.010	4.260 4.240		
2	Wearpad	3.500inches ± 0.010	3.510 3.490		
3	Wearpad	1.970inches ± 0.030	2.000 1.940		
4	Wearpad	3.630inches ± 0.030	3.660 3.600		
5	Wearpad	2.420inches ± 0.010	2.430 2.410		
6	Wearpad	0.220inches ± 0.010	0.230 0.210		
7	Wearpad	0.375inches ± 0.010	0.385 0.365		
8	Wearpad	0.063inches ± 0.010	0.073 0.053		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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